

24

Date: Wednesday, 5/23/2007 3:16:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE LH 206A/B - UNDER REVIEW
 Job Number : 32452
 Estimate Number : 10801
 P.O. Number :
 This Issue : 5/23/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : LANDING GEAR
 Previous Run : 32451
 Part Number : D206642611
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : N/A
 Material :
 Due Date : 6/15/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: B 05.10.27 Revised pick list KJ/EC

PH
07.05.24

POSITIVE
RECALL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-611 CHG001

2.0 32452A FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW



Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B
 D206-642-641 B

3.0 D206651041 206 A/B GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 1 D206651041 GHW Kit Batch:

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: D2652 Bushing

Qty Part Number Description Batch

15 D206-651-041 GHW Adaptor

5.0 D26651 Saddle, LH Fwd Aft Out



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2665-1 Saddle

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: FLOAT SKIDTUBE LH 206A/B - UNDER REVIEW

Job Number: 32452

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26661

Saddle, LH, Fwd,Aft, In



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2666-1 Saddle _____

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw _____

8.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2884 Saddle Spacer _____

9.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2885 Saddle Spacer _____

10.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3396-3 Spacer _____

11.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 AN3C36A Bolt _____

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE LH 206A/B - UNDER REVIEW

Job Number: 32452

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN3C41A Bolt

13.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN4C6A Bolt

14.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batc

4 AN5C7A Bolt

15.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C11A Bolt

16.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5C13A Bolt

17.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN5C32A Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: FLOAT SKIDTUBE LH 206A/B - UNDER REVIEW

Job Number: 32452

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batc

1 AN5C35A Bolt _____

19.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batc

2 AN6C44A Bolt _____

20.0

AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 AN960C10L Washer _____

21.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 AN960C416L Washer _____

22.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN960C516L Washer _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32452

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960C616 Bolt _____

24.0

MS210433

Nut



Comment: Qty.: 17.0000 Each(s)/Unit Total : 17.0000 Each(s)

Pick:

Qty Part Number Description Batch

17 MS21043-3Nut _____

25.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4Nut _____

26.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21043-5Nut _____

27.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 ms21043-6 Nut _____

28.0

NAS1515H3L

WASHER



Comment: Qty.: 18.00000 Each(s)/Unit Total : 18.00000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES					
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Drawing Name: FLOAT SKIDTUBE LH 206A/B - UNDER REVIEW

Job Number: 32452

Part Number: D206642611

Job Number:



Seq. #:

Machine Or Operation:

Description :

18 NAS1515H3L Washer

29.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 NAS1515H4L Washer

30.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 NAS1515H5 Washer

31.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 NAS1515H5L Washer

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-611

Location: _____

PPP Rev: _____

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL
EFFECTIVE 07/21/07 AUTH 4
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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24

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Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32452A
Estimate Number : 10803
P.O. Number :
This Issue : 5/23/2007 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : LANDING GEAR
Previous Run : 32451A
Written By :
Checked & Approved By : 07.05.24
Comment : Est Rev:B 05-11-15 Added washers for aft cap, wearshoes and ring EC
Est Rev:C 06-05-31 Revised steps JLM
Est Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM

Drawing Name : FLOAT SKIDTUBE HIGH GEAR 206 A/B-UNDER REVIEW
Part Number : D206642641
Drawing Number : D3288 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 6/15/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-641 CHG002

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 3" OD Bent Tube B31482 NP 7-6-6

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap 229328 BE 070607

4.0

D32861

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B29090

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr FWD edge of tube, grind bending marks.

2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.

3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit

AVR AL ROD

Batch: *M102421/M104305 BE 07-06-07*

4-Grind welds flush to cap on top surface only.

BE 07-06-07

5-Cut Aft end as per Dwg D3288 from front of tube then deburr

6-Remove inner indexing ridge on aft end as per Dwg d3288

7-Open holes for aft cap as per Dwg D3288 using Dt8025

8-Drill pilot holes using DT8818

9-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the D3286-1 doubler, leave Dt8732 for added support

3/16" holes cleco

10-Drill D3286-1 doubler rivet holes in tube using #40 drill, spot drilling doubler at the same time.

11-Working from center out, drill #30 holes into D3286-1 Doubler. cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.

12-Remove 3/16" clecos only and open GHW holes to .500" as per Dwg D3288.

13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pr 07-06-13 (1)



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-06-13

9.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total: 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

m16896

Pr 07-06-13 (1)

10.0

D3289041

Float Web (206A/B)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3289-041 Float Web

B24864

Pr 07-06-13 (1)

11.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Holes to finished size as per DWg D3288.Deburr.

Pr 07-06-13 (1)

2-Locate, install and rivet doublers as per Dwg D3288. Micro-shave rivets as required.

Pr 07-06-13 (1)

3-Bond web in place as per Dwg D3288 & QSI 015.

A/R Sikaflex-291

m163561

Sikaflex expire date:

01-10-01

Start:

07-06-13

Time: *12:30*

Finish:

07-06-21

Time: *4:00pm*

(Adhere for 12 hours)

Pr 07-06-13 (1)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP / [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Wednesday, 5/23/2007 3:17:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B 2 UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.

Handwritten: 25/EL 27-4

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

Handwritten: Pm 07-07-04 (1)

2-C'sink X-bolt holes.

Handwritten: Pm 07-07-04 (1)

3-Debur

Handwritten: Pm 07-07-04 (1)

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D2649 Crossbolt spacer

Handwritten: B31926

Handwritten: Pm 07-07-10 (1)

16.0

D32751

Crossbolt Spacer



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick:

Qty Part Number Description Batch

9 D3275-1 Crossbolt spacer

Handwritten: B31072

Handwritten: Pm 07-07-10 (1)

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3

Spacer

Handwritten: B 322515

Handwritten: BE 070717

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.

AVR Aluminum Rod M 104221 BE 07-07-11

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required

AVRSS Rod NONE BE 07-07-17

3-Grind welds flush to Fwd cap on top surface only. P 07-07-17

4-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

5-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

Pm 07-07-11
DP
7-7-17

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/18

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/18

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1X

Pressure wash as per QSI 005

M. J.

07/08/15

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL/M 07-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/08/21 (1)

24.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate

B33434

esl

25.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet

M103525

esl

26.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet

M115918

esl

27.0

ALS71032130

Insert



Comment: Qty.: 64.0000 Each(s)/Unit Total : 64.0000 Each(s)

Insert

Batch: *M1102479*

esl

28.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3

A/R LPS-3 Batch: _____

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes

A/R Sikaflex-291 _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:17:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

Sikaflex expire date: _____

29.0

QC5

INSPECT WORK TO CURRENT STEP



P70

Comment: INSPECT WORK TO CURRENT STEP

Inserts & Nut plate

30.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1332737

MS

31.0

D353521

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1329188

MS

32.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1333371

MS

33.0

D353541

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1331993

MS

34.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1332746

MS

35.0

D353621

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

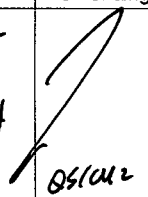
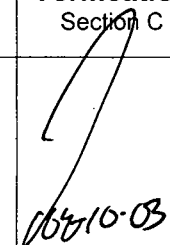
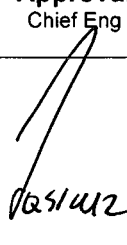
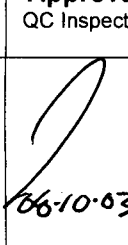
1331995

MS

07-08-21 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-641 PAR #: N/A Fault Category: Prod/Sketch NCR: Yes No DQA: 12 Date: 09/10/06
 NCR QA: N/C Closed: _____ Date: _____

NCR: 32452A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-03	29.0	Part is un-acceptable per NCR 203. Ground handling interferes with the float bag installation. R.C: Design.	 08/10/03	Scrap: destroy, no replace.	RT 08-10-03	 08/10-03	 08/10/03	 08-10-03

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:17:54 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description:

36.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B32788 *lll*

37.0

D353641

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B31997 *lll*

38.0

D35371

WEARPAD



Comment: Qty.: 7.0000 Each(s)/Unit Total: 7.0000 Each(s)

WEARPAD

Batch: B33660 *lll**Take scrap.*

39.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

Batch: B33285 *lll*

40.0

AN3C4A

BOLT



Comment: Qty.: 66.0000 Each(s)/Unit Total: 66.0000 Each(s)

BOLT

Batch: M105143 *lll*

41.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3L Washer M104603 *lll*

42.0

AN960C10L

washer



Comment: Qty.: 64.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

M105143 *lll* 07-08-21

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:17:54 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

64 AN960C10L Washer

43.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33433*jel*

44.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M18916*jel*

45.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer

46.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap

47.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960C10L Washer

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:17:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE HIGH GEAR 206 A/B - UNDER REVIEW

Job Number: 32452A

Part Number: D206642641

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearshoes/wearpads & Gaskets as per Dwg D3288.

3-Install Ring on Nut Plate as per detail F & Dwg D3288.

4-Spray inside tube with LPS-3 on both sides of web

5-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 _____

Sikaflex expire date: _____

6-Coat all exposed fastners with LPS Procyon,remove any exess on powder coat
with MEK Degreasser.

A/R LPS Procyon Batch: _____

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-641

Location: _____

PPP Rev: _____

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3288	REV. C SHEET 1 OF 3
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **H**

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
1	D2646	AFT CAP
9	D2649	CROSS BOLT SPACER
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
66	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
2	NAS1515H3L	WASHER

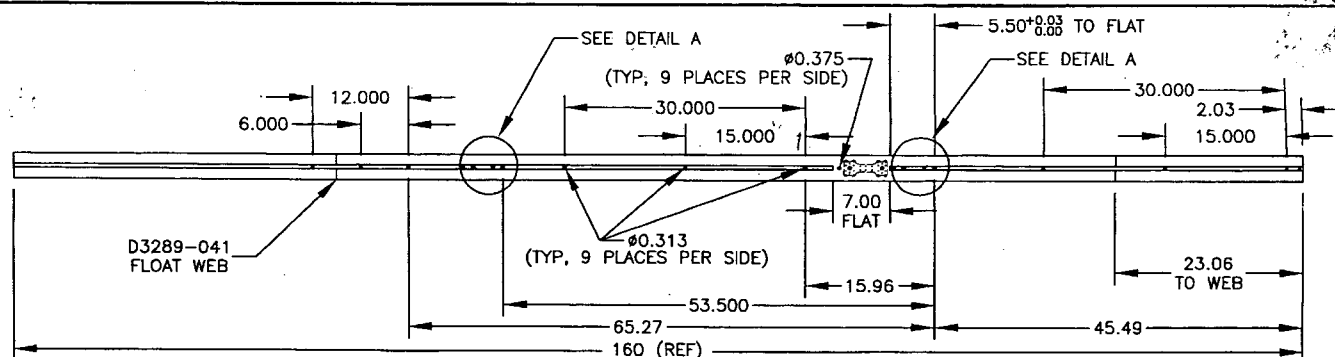
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

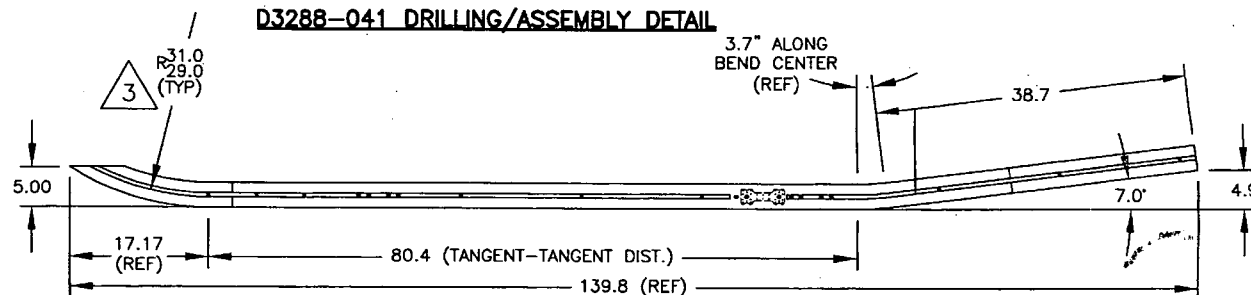
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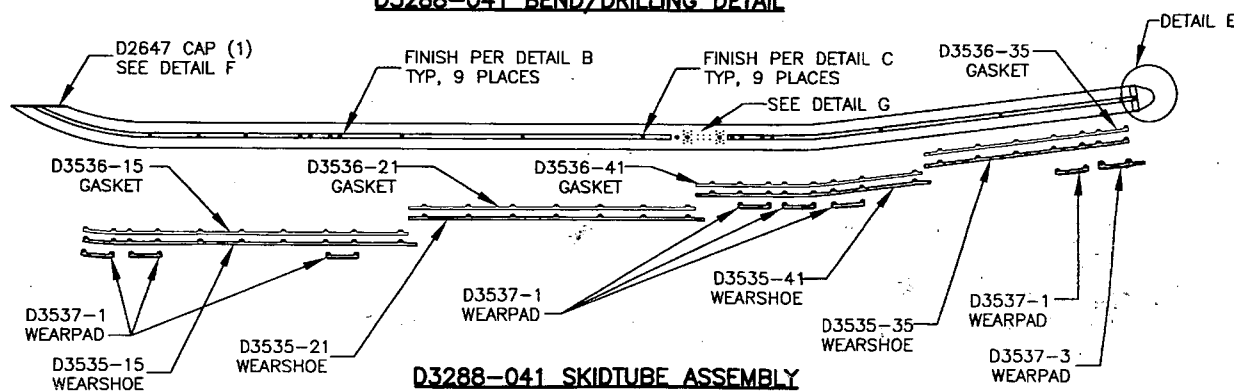
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WORK ORDER
NO. **32452** **A**



D3288-041 DRILLING/ASSEMBLY DETAIL



D3288-041 BEND/DRILLING DETAIL



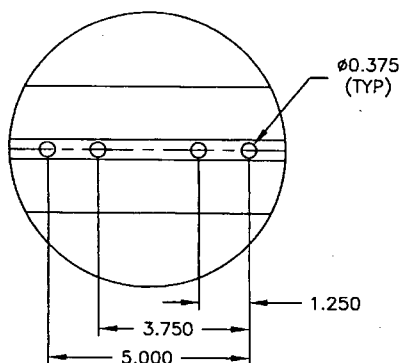
D3288-041 SKIDTUBE ASSEMBLY

RELEASED
07.07.12

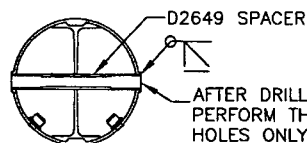
NO. 32452A
WORK ORDER
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CHECKED	APPROVED	DRAWING NO.	REV. C	
DATE	06.12.19	D3288	SHEET 2 OF 3	
		TITLE	SCALE	
		SKIDTUBE ASSEMBLY	1:15	

DETAIL A: DRILL DETAIL

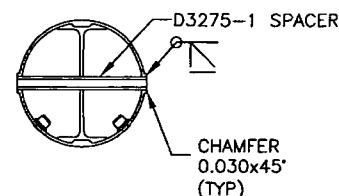


DETAIL B FOR 0.375 HOLES ONLY

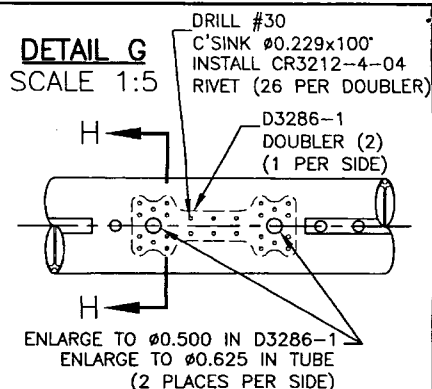


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO 0.313x0.75 DEEP

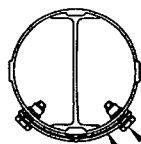
DETAIL C FOR 0.313 HOLES ONLY



DETAIL G SCALE 1:5

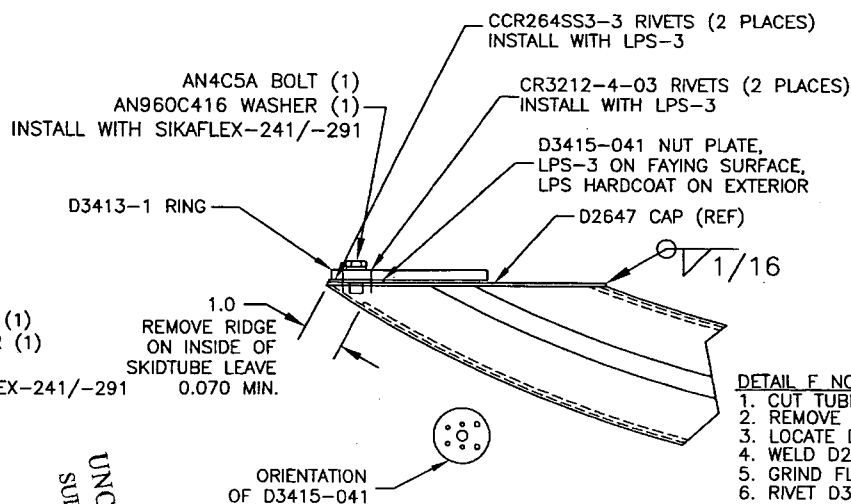


DETAIL D



ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(64 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL E

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

0.400

NO. 32452A
WORK ORDER
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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3288
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. C SHEET 3 OF 3 SCALE 1:3

NO. 117

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure TIG
Part number and Job number 2066042541 / B33182A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

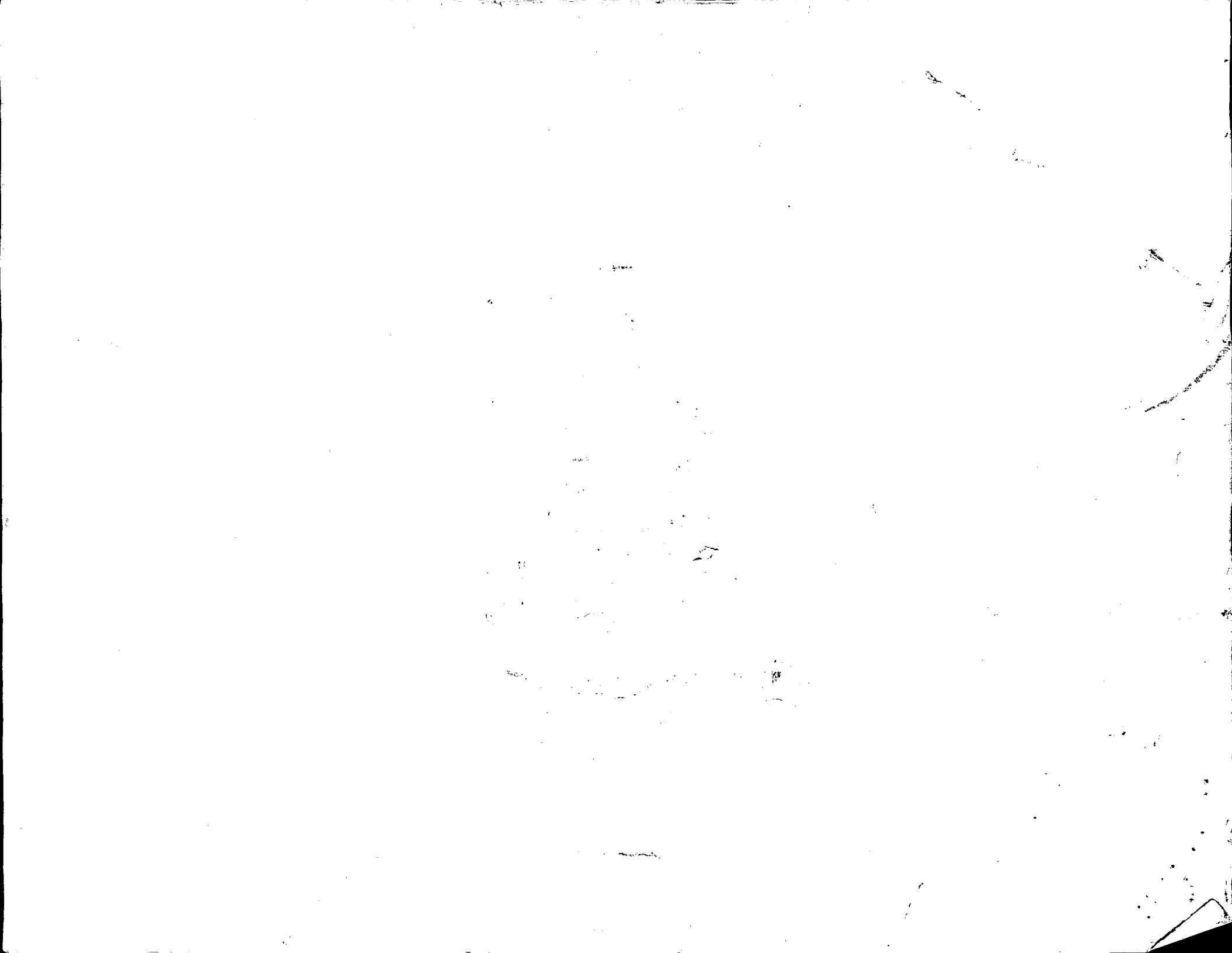
Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/16 Qualifier David Sand



L Lacelle

From: Dan Stow [dstow@dartaero.com]
Sent: August 16, 2007 11:51 AM
To: 'L Lacelle'; 'Jean-Luc Menard (E-mail)'
Subject: RE: Air Log - pls review

D206-642-611/612/613/614/641

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: August 16, 2007 11:39 AM
To: 'Dan Stow'; 'Jean-Luc Menard (E-mail)'
Subject: RE: Air Log - pls review

Do you have the exact P/N's ????????????

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: August 16, 2007 11:35 AM
To: 'Jean-Luc Menard (E-mail)'; Linda Lacelle (Linda Lacelle)
Subject: FW: Air Log - pls review

Please stop any production of D206AB float tubes as per NCR 203.

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: August 16, 2007 10:04 AM
To: 'Peggy McDonald'; 'pbravo@apicalind.com'
Cc: 'Bill Beckett (Bill Beckett)'; 'David Shepherd (David Shepherd)'; 'Marc Bellavance (Marc Bellavance)'; 'Mike Petsche'
Subject: RE: Air Log - pls review

Peggy,

This is not going to be a quick and easy fix. Dart has to redesign the skidtube to accommodate the float bag and the OEM/BRACKETTE ground handling wheels, which could mean locating the float bag more fwd. I hesitate to give a time line but I would say best case scenario for a new skid would be three weeks.

21/08/2007